



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW6505G00831-3G-19

Job Sheet 180088



Part No: RBW6505G00831-3G-19

Job Qty: 6 ea

Part Name: Swivel Base



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/28/18

Job Tracking No:

Due Date: 7/6/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: URF17-785 DWG RBW6505G00831-3G Rev2 IPP Rev A 17.11.21 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		7/6/18	0.00	0.00	Start Up Container		
100	Bandsaw	6 pcs		7/6/18	0.00	1.50	Bandsaw1		
110	Mori Seiki	6 pcs		7/6/18	0.00	6.00	MORI SL2500Y		
120	QC	6 pcs		7/6/18	0.00	0.00	QC2		
122	Mori Seiki	6 pcs		7/6/18	0.00	6.00	MORI NV5000-1		
124	QC	6 pcs		7/6/18	0.00	0.00	QC2 Machining-1		
130	QC	6 pcs		7/6/18	0.00	0.00	QC8		
150	Outsource	6 pcs		7/6/18	0.00	0.00	Outsource13		
160	Packaging	6 pcs		7/6/18	0.00	0.00	Packaging2		
170	QC	6 pcs		7/6/18	0.00	0.00	QC6		
180	Packaging	6 pcs		7/6/18	0.00	0.00	Packaging3		
190	QC21-SA	6 Ea		7/6/18	0.00	0.00	QC21		

Part Op 100 - CUT TO 1.470" LENGTH

Descriptions: 110 - 1-Machine as per folio FB677 FOLIO REV: AA DWG REV: 2 2-Deburr

122 - 1-Machine as per folio FB677 FOLIO REV: AA DWG REV: 2 2-Deburr

150 - Issue P/O to GROUPE ALTECH: P/O 040564 Zinc plate, ASTM B633 TYPE 2 SC2 -Color: yellow -Material type; A36 -Certificate of Conformity is required

160 - C of C is required.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-HRS-R-7.000	Hot Rolled Steel Round Bar 7.000" dia. (cut to 3.5" length)	.7380 ft (.123 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-HRS-R-7.000	1	4	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																							
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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																																							
Description Work Order Deviation		Disposition		Completed By																																							
Dart Aerospace Ltd. 1270 Aberdeen Street Aberdeen, ON M6A 1K7 CANADA TEL : 1 513 632-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 06/29/18 Container No: S088458 Part: RBW6505G00831 - 3G - 19 Job No: 180088 Serial No/Batch: S088458 Revision: 2 Inspector: Exp Date: Instructions: ication ☐ up ☐ iting ☐ nation ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY <table style="width:100%; border: none;"> <tr> <td style="border: none;">Pressure/Forced ☐</td> <td style="border: none;">Temperature/Cure ☐</td> <td style="border: none;">Power Loss/Surge ☐</td> <td style="border: none;">Positioned Wrong ☐</td> </tr> <tr> <td style="border: none;">Bending ☐</td> <td style="border: none;">Set-up ☐</td> <td style="border: none;">Folio/Program ☐</td> <td style="border: none;">Outside Dimensions ☐</td> </tr> <tr> <td style="border: none;">Centre Not Concentric ☐</td> <td style="border: none;">BOM/Route ☐</td> <td style="border: none;">Grain ☐</td> <td style="border: none;">Over/Under tolerance ☐</td> </tr> <tr> <td style="border: none;">Cracks ☐</td> <td style="border: none;">Broken/Damage/Defect ☐</td> <td style="border: none;">Weld ☐</td> <td style="border: none;">Part Incorrect ☐</td> </tr> <tr> <td style="border: none;">Crimp/Kink/Ripple/Wave ☐</td> <td style="border: none;">Inspection Incomplete/Unqualified ☐</td> <td style="border: none;">Wrong Stock Pulled ☐</td> <td style="border: none;">Part Lost/Missing ☐</td> </tr> <tr> <td style="border: none;">Cuffs ☐</td> <td style="border: none;">Contamination ☐</td> <td style="border: none;">Out of Sequence ☐</td> <td style="border: none;">Part Moved ☐</td> </tr> <tr> <td style="border: none;">Crushing ☐</td> <td style="border: none;">Countersink ☐</td> <td style="border: none;">Off-set ☐</td> <td style="border: none;">Drawing ☐</td> </tr> <tr> <td style="border: none;">Heat Treat ☐</td> <td style="border: none;">Cut Too Short ☐</td> <td style="border: none;">Mislabeled ☐</td> <td style="border: none;">Finish ☐</td> </tr> <tr> <td style="border: none;">Wave/Twist in Tube ☐</td> <td style="border: none;">Instructions Incomplete/Unclear ☐</td> <td style="border: none;">Fit/Function ☐</td> <td style="border: none;">Misread ☐</td> </tr> <tr> <td style="border: none;">Marks/Chatter ☐</td> <td style="border: none;">Drill Holes ☐</td> <td style="border: none;">Misaligned/off center ☐</td> <td style="border: none;">Turning Sequence ☐</td> </tr> </table>		Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
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OTHER : _____																																											

This drawing, specifications, and concepts contained here in are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
2	-19 CH'D COUNTER BORED HOLES B.C. FROM Ø5.375 TO Ø5.512.	7/12/2013	RJC	RW

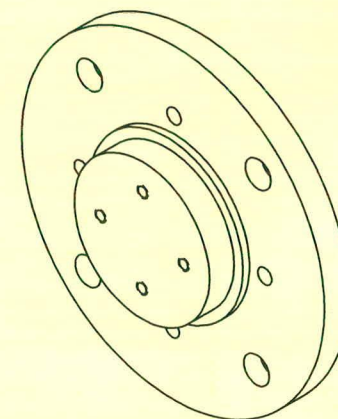
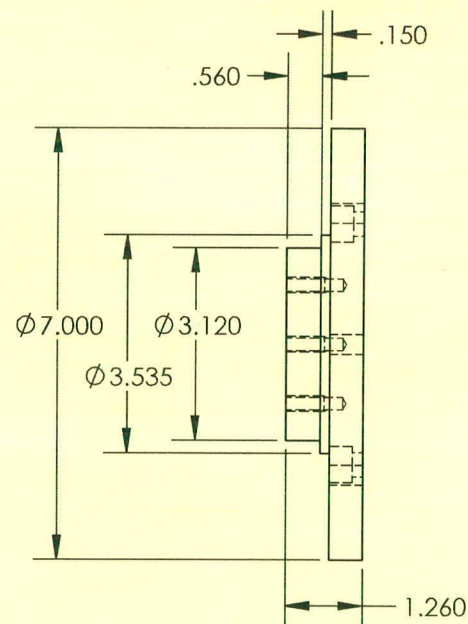
TEO ATTACHED

ENGRAVE P/N
"RBW6505G01251-3G"

4X $\phi .323$ THRU
ON B.C. $\phi 4.240$
EQUALLY SPACED

4X 1/4-20 UNC $\nabla .625$
ON B.C. $\phi 1.920$
EQUALLY SPACED

4X $\phi .397$ THRU ALL
 $\square \phi .590 \nabla .375$
ON $\phi 5.512$ B.C.
EQUALLY SPACED



(-19)

SWIVEL BASE

RED BARN MACHINE	
TITLE TROLLEY ADAPTER, TGB SUPPORT	
DWG NO. RBW6505G00831-3G-19	REV 2
MAT'L 1018	DRAWN BY: CLOUGH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX $\pm .005$	HEAT
.XX $\pm .01$	TREAT
.X $\pm .1$	FINISH
ANGLES $\pm 5^\circ$	SPEC QQ-P-416F, TYPE II, CLASS II
1. BREAK ALL SHARP EDGES .015 x 45°	USED ON MODEL
OR .015R	AW139
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:3	DATE 1/20/2012
SHEET 12 OF 16	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

880521

10-2-720 V110

10-2-720 V110

880520

3AG

52

10-2

14

10-2-720



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040564**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO040564
PO Date: 7/23/18
Due Date: 7/27/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	180088	RBW6505G00831-3G-19	Swivel Base -Issue P/O to GROUPE ALTECH: P/O -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; A36 -Certificate of Conformity is required	Firmed	-	7/27/18	6 pcs	0 pcs	6 pcs	\$15.00/pcs	\$90.00

DAS
61
9-89

6x

AUG 03 2018

Grand Total: \$90.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

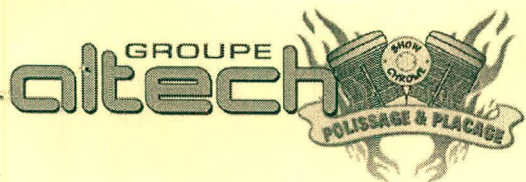
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/24/18 7:57 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(011278-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

011278- 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
31-Jul-2018		Aman		040564				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities		
						Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBW6505G00831-3G-19 Rev.	RBW6505G00831-3G-19 01 -ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE, 96 hours TYPE 2 SC2	ZINC CH	6	6	0	0	0

**DAS
61
9-89**

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness
Inspecteur Qualité
Quality Inspector
Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

